

Ship Thurs 28/07 - Single

Work Order ID 72475

Tuesday, July 26, 2011 9:10:07 AM



Page 1

Item ID:	D4165-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	7/26/2011	Start Qty:	1.00			
Required Date:	7/29/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	11-07-26	Tooling:		Date:		Run	Start	
	QC:	Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4165	B								

100		Waterjet	FLOW CNC Waterjet	Memo	1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary	0.00	<u>11/07/27</u>	<u>1</u>	
110		QC	Quality Control	Memo	QC2- Inspect parts off machine FAI/FAIB	0.00	<u>11/07/27</u>	<u>1</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4165-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 7/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>M</u>	<u>11</u>	<u>07</u>	<u>28</u> (7)
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>M</u>	<u>11/07/28</u>	<u>1</u>	<u>φ</u>
135 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>1</u>	<u>BR 11-7-28.</u>		

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Setup Start



Revision ID:

Stop



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Start Date: 7/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: 139K

0.00



Packaging

Memo

0.00

Packaging

11/7/28

12

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/28

11-07-28

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Picklist Print

Tuesday, July 26, 2011 9:10:13 AM

Page 1

Work Order ID: 72475



Parent Item: D4165-1



Parent Item Name: Doubler

Start Date: 7/26/2011

Required Date: 7/29/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	202.5684	0.353	0.371579			



2024-T3 .040 sheet



Location

Loc Qty

Loc Code

MAT022

202.568421

112291

0.5

112331

0.7

113162

18.1

117684

183.268421

.4 ~~PO~~ 11/07/27

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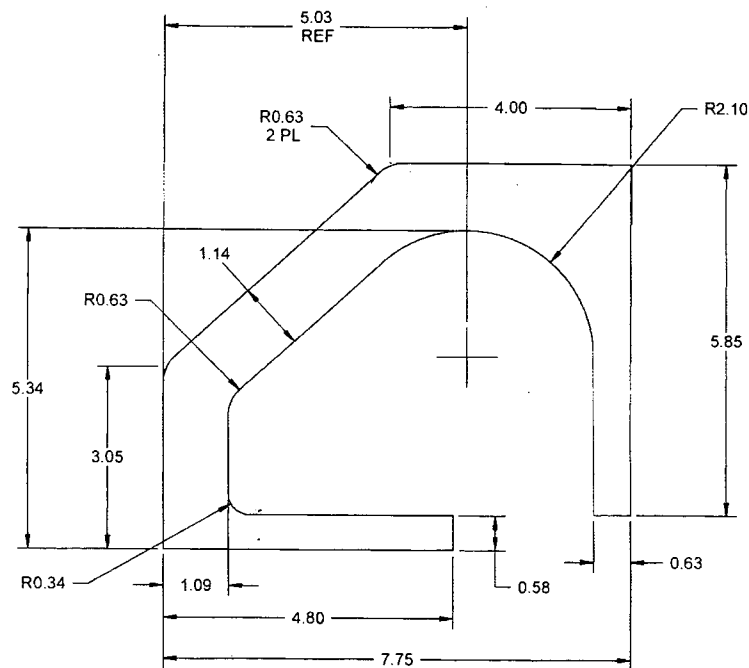
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72475

0.040
REF

D4165-1 DOUBLER

RELEASED
R 2011-04-15
M

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

B	CORRECTED BEND ORIENTATION ON D4165-9 (ZN C1-5)	RF	11.04.11
A	NEW ISSUE	RF	10.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.04.11		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4165	REV. B
TITLE VRD PARTS	SCALE NTS
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